Work Orde January-18-13				*957	70*						Page 1
Revision ID:	D2366 Lock Handle		A	Accept	*N900	<u>)</u> 040	100)* s	etup Start Stop	14.	S1* S2*
	1/16/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item Customer					IV.	
Approvals:		in: MC5		Tooling: SPC (Y/N):		Date:		R	tun Start Stop	1/1	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D2366	Rev	, C									
*100 *100* Waterjet FLOW CNC Waterj		FLOW WATER JET Memo 1-Cut as per Deburr if nec		0.00 0.00 C'Prog Rev:	_ 2-			_/0_	6		Jm13-3-12
110		QC2- Inspect parts off m	achine FAI/FAIB	0.00				(0	<u>ن</u>		Jm 13 3-1
QC Quality Control		Memo		0.00	· .						<u> </u>
*120		QC8- Inspect parts - seco	and check	0.00 Sm				ÍÒ			
QC		Memo		0.00 133	レン			10			

Quality Control

NCR:	Yes	/ No				WORK ORDER NON-	100	VFORN	ANCE / UP	DATE			
,											QA Closed:	Date	:
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Part N	No.		7-			Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	Π	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
11							AUL	T CATE	JORY			 	
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection	Crimped. t n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instructi Mainte Mislabe Misread	on incomplete ions incomplete/ nance led	Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Dinnloc in	Rond			Drill Holos	1	Officet					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord January-18-13				*957	770*						Page
Item ID: Revision ID: Item Name:	D2366 Lock Handle			Accept	*N900	040	100)* s	etup Star Stop	14	S1*
Start Date: Required Date Reference:	1/16/13 : 1/31/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:				I VI	.7/
Approvals:		in: .	Date:			nte:		R	tun Star Stop	" \	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Small Fab Small Fab		Small Fab Memo Tumble and	stock	0.00				10	_#	7/05	000

140

150

Identify as per dwg & Stock Location: \$1605 0.00

140 Packaging

Memo

0.00

Packaging

150

Memo

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

13/3/22 Sy MF

Page 2

									DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-C	CONFOR	MANCE / UP				
									QA Closed:	Date:	
Work Order	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
					Rework	1 1	Skid-tube	Crosstube		Water Jet	Engineering
Part No	o .				Scrap	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Finishing		re/Packaging	Other
NCR No	o				Work Order Update		Large Fab	Composite		Supplier	
			· · ·								
Root		•		Descri	ption of work order update	Initial	Ac	ction	Sign &	}	
Cause	Date	Step	Qty	C	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material							-				
Setup	_						1				
Other						İ					
Process											
Supplier					•						
Training											
Unapproved		<u> </u>				<u> </u>					
					F.	AULT CATI	GORY				

andır	ng (gear	General			
[Bending	Bend	Grain	Ovalized	Pressure/Forced
		Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
L		Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
		Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
		Cuffs	Contamination	Maintenance	Part Moved	
L		Heat Treat	Countersink	Mislabeled	Positioned Wrong	
		Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
		Ripples in Bend	Drill Holes	Offset		
		Torque Waves in Extrusion	Drawing	Out of Calibration		
		Turning Sequence	Finish	Out of Sequence		
		Wave/Twist in Tube	Folio	Outside Dimensions		

Picklist Print

January-18-13 10:47:16 AM

Work Order ID:

95770

Parent Item:

D2366

Parent Item Name: Lock Handle

Start Date: 1/16/13

Required Date: 1/31/13

Page

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP B00.05.04ReformatEC

IPP ReviC Now on Wateriet 07-04-20 II M

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 304/316 .040 Sheet		Purchased	No			100	sf	385.1001	0.0174	4.183158 0.25			Jm13-3-1
				Location		Loc Qty	Lo	c Code					
				MAT020		385.100065							
				121	380	0.000065							
				122	732	32							
				122	753	98.8							
				124	029	254.3			1240) <u>a</u> 9			

											DQA	: Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE				
<u> </u>		····							·		QA Closed	: Da	ite:	
Work Ord	or.					DISPOSITION				AGAINST DE	PARTMENT	r/PROCESS		
Work Old	C1.					Rework	1		Skid-tube	Crosstube		Water Jet	Γ	Engineering
Part I	No.					Scrap	1] ;	Machining	Small Fab	Pro	od. Eng. Coor.	\vdash	Quality
						Use-as-is	┪ .		noforming	Finishing	1	re/Packaging	-	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite	·	Supplier		
							_				-			
Root			ŀ		1	ption of work order update		Initial	Acti	on	Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verificatio	'n	QC Inspector
Doc/Data					! 									
Equip/Tooling														
Operator													1	
Material]											
Setup														
Other														
Process														
Supplier														
Training		i												
Unapproved		=												
						F	AUI	T CATE	GORY					
Landi	ng (Gear				General		-			=		_	
		Bending				Bend		Grain			Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re	[Over/Unde	r tolerance		Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete		Part Incorrect		Weld	
	Crushed/Crimped.		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing			Wrong Stock Pulled				

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95770
Description: Lock Handle	Part Number:	D2366
Inspection Dwg: D2366 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.191	+0.005/-0.001	0.192"	-		ν	Jkmoi
0.750	+/-0.010	O.757"	_		v	
0.344	+/-0.010	0.344"	_		V	
1.196	+/-0.010	1.200	_		V	
2.750	+/-0.010	2-753"	-		ν	
					· · · · · ·	

Measured by: Jm	Audited by:	Prototype Approval:	N/A
Date: 13-3-12	Date: 13 3 10	Date:	N/A

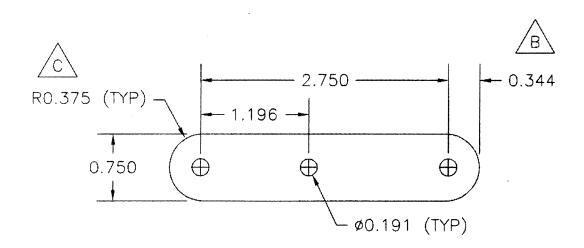
Rev	Date	Change	Revised by	Approved
Α	08.02.28	New Issue	KJ/DD	777





	DESIGN BW		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHEC	4.5	APPROVED	DRAWING NO. REV. C
	٠	H	- ##	D2366 SHEET 1 OF 1
	DATE			TITLE SCALE
	00.0)4.24		LOCK HANDLE 1:1
	Α		95.02.20	NEW ISSUE
	В		96.06.10	R0.50 WAS R0.354; 0.344 WAS 0.300
	C		00.04.24	R0.375 WAS R0.50





MATERIAL: AISI 304/316 SS.0.040 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED ALL DIMENSION ARE INCHES